



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18538-1
Job Sheet 169532



Part No: RBT18538-1

Job Qty: 5 ea

Part Name: Left Seat Brace



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/15/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18538 Rev2A IPP Rev A 17.12.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		12/14/17	0.00	0.00	Start Up Waterjet2		OK 17/12/13
100	Waterjet	5 pcs		12/14/17	0.00	0.50	Waterjet 2 OMAX		OK 17/12/13
110	QC	5 pcs		12/14/17	0.00	0.00	QC2 Waterjet-4		OK 17/12/13
120	QC	5 pcs		12/14/17	0.00	0.00	QC8-7		38
130	Brake NC	5 pcs		12/15/17	0.00	1.25	Brake NC 1		9-89
140	QC	5 pcs		12/15/17	0.00	0.00	QC5		
150	Outsource	5 pcs		12/15/17	0.00	0.00	Outsource4		
160	Packaging	5 pcs		12/15/17	0.00	0.00	Packaging2		
170	QC	5 pcs		12/15/17	0.00	0.00	QC6		
180	Packaging	5 pcs		12/15/17	0.00	0.00	Packaging3-1		
190	QC21-SA	5 Ea		12/15/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 2 Prog Rev: 2 2-Deburr if necessary (Reel Barn)

Descriptions: 130 - Form as per DWG sheet 2

140 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

150 - -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M5052H32S.040	2	187	0	0

Part Specifications

Specifications could not be found.

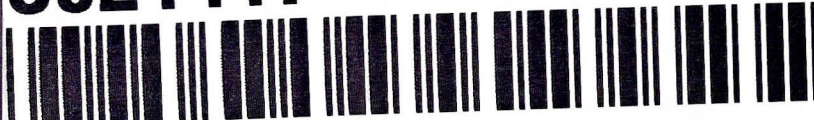
Plex 12/13/17 11:52 AM Dart.lajeunesse.marie



DQA: _____ Date: _____
QA Closed: _____ Date: _____
WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

DART
AEROSPACE
S021417



Left Seat Brace

PART NO:
Revision:
Operation:
Change No:

RBT18538 - 1

Start up Operation

Mfg Date: 12/13/17
Job No: 169532

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐
Part No. _____		
NCR No. _____		
Date: _____	Step #: _____	
Description Work Order Deviation		

Root Cause		Pressure/Forced	
Environment ☐	No Re-verification ☐	☐	☐
Design ☐	Operator ☐	☐	☐
Doc/Data ☐	Offset/Setup ☐	☐	☐
Equip/Tooling ☐	Supplier ☐	☐	☐
Handling/Pre ☐	Training ☐	☐	☐
Material ☐	Use for Testing ☐	☐	☐
Internal Transport ☐	Poor Information ☐	☐	☐
Tribal Knowledge ☐	Rushing ☐	☐	☐
LOA ☐	Product Improvement ☐	☐	☐
Substation ☐	Process Improvement ☐	☐	☐
Past Expiry Date ☐	Manufacturing Process ☐	☐	☐
Misidentified ☐	Past Due ☐	☐	☐
		OTHER : ☐	

et ☐	or ☐	ig ☐	er ☐
Engineering ☐	Quality ☐	Other ☐	

MRB (QS1042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
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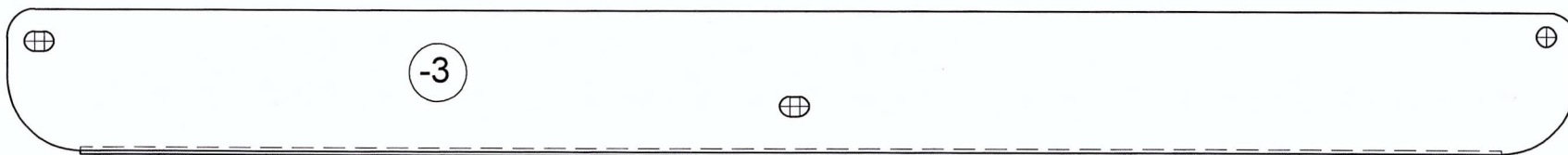
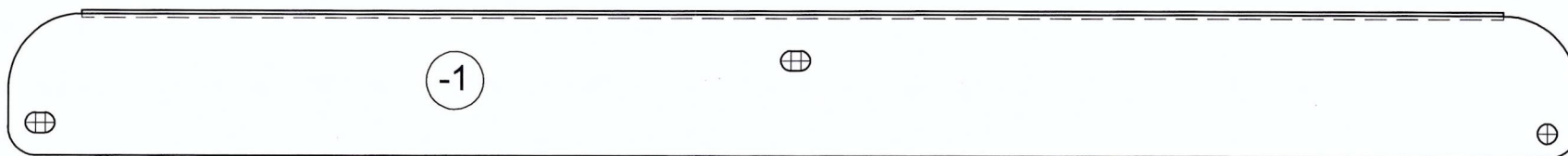
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Fit/Function ☐
Misaligned/off center ☐

Instructions Incomplete/Unclear ☐
Drill Holes ☐

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ORIGINAL TOOL WAS A MACHINED SOLID PART, NOW A FORMED PART.	10/7/10	WP	
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO Ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

Added B & L & 407 to used on
model 3/20/12 after DW veified
the hole pattern is the same.
No rev done. RJC

ASSY QTY	ASSY #	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	LEFT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
			-3	1	RIGHT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-7-10
SHEET 1 of 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

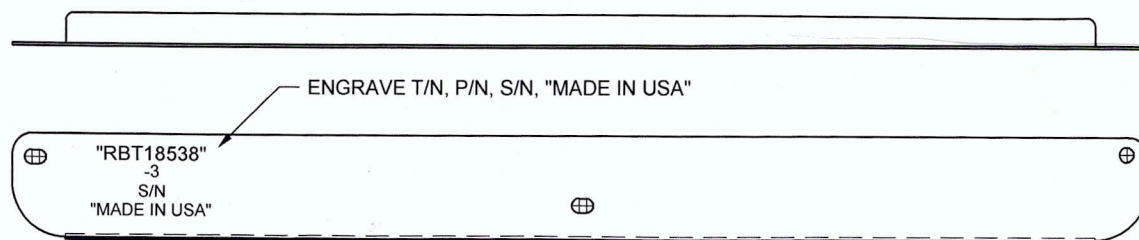
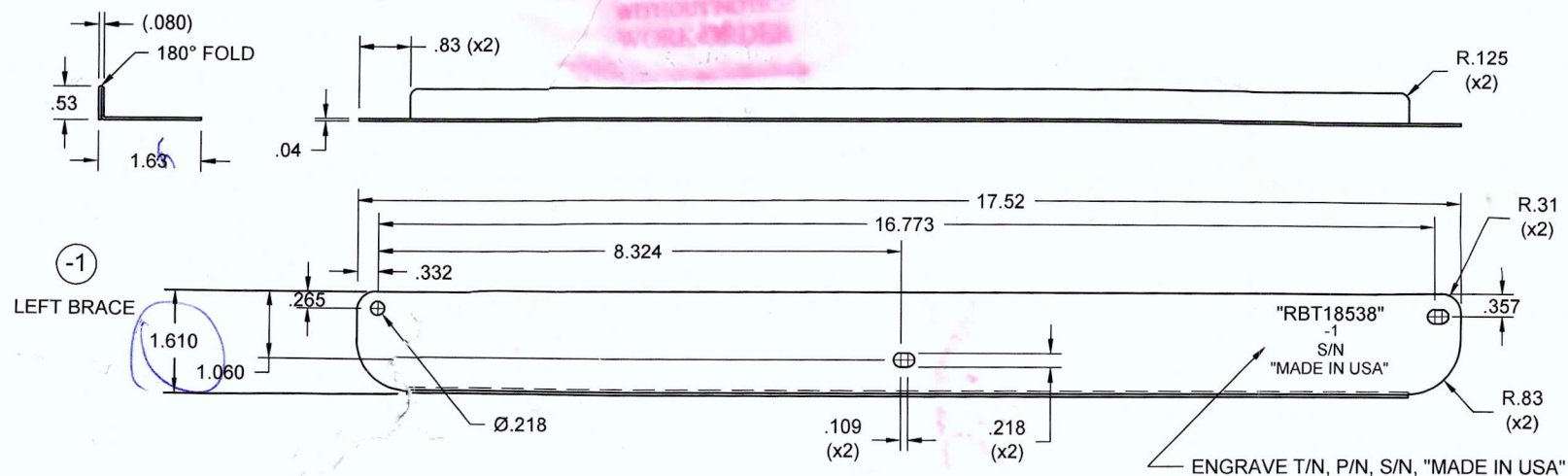
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



RIGHT BRACE
(DIMENSIONALLY OPPOSITE LEFT BRACE)

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XX ± .005 FRACTIONS 1/32 ANGLES ± 5°	
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-7-10
SHEET 2 of 2	
DRAWN BY: PERRITT	
APPROVED <i>D Wed</i>	
HEAT TREAT FINISH CLEAR ANODIZE	
SPEC MIL-A-8625F, TYPE II, CLASS I	
USED ON MODEL BELL 206 B & L, 407	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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